

Work Order ID 104674

\*104674\*

Page 1

Friday, July 12, 2013 12:41:22 PM

Item ID: D3507-1-BENT

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Skidtube Assembly EC135

Start Date: 7/12/2013 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 7/18/2013 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: *[Signature]*

Date: *13-07-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3507

Rev C

120

0.00

\*120\*

BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend tube as per program D3507 on CNC Bender FOLIO 6 and Dwg D3507,  
use DT9632 bending aide  
2- Cut FWD END of tube as per dwg D3507

*DC 13/09/65*

*PTO*

140

QC5- Inspect part completeness to step on W/O

0.00

\*140\*

QC

Memo

0.00

Quality Control

*DP 13-9-5*

300

Identify as per dwg & Stock Location: *46*

0.00

\*300\*

Packaging

Packaging

Memo

0.00

Packaging

*DP 13-9-5*

*(2)*

DQA: Autz Date: 13/09/17  
 QA Closed: Autz Date: 13/9/16

# WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only ☐

Work Order: <u>104674</u> Part No: <u>D3507-1-BENT</u> NCR No: <u>13-3028</u>	<b>DISPOSITION</b> Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b> Skid-tube <input checked="" type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Engineering <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Quality <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Other <input type="checkbox"/> Supplier <input type="checkbox"/>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									
	13-9-5	120	2	<u>2 D2962-150</u> <u>B#90871 crushed</u> <u>while Banding.</u> <u>RC: Process</u>	W 13-9-5	<u>Scrap &amp; replace</u> <u>D2962-150</u> <u>B90871 QTY2</u> <u>PA; Adjusted Band</u> <u>program to</u> <u>compensate.</u> <u>\$49.10</u>	<u>AL</u> <u>13/09/05</u>	<u>DD</u> <u>13-9-5</u>	<u>DAS</u> <u>16</u> <u>9-89</u> <u>13/09/05</u>

## FAULT CATEGORY

<b>Landing Gear</b> <input checked="" type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 104674****\*104674\***

Page 2

Friday, July 12, 2013 12:41:22 PM

Item ID: D3507-1-BENT

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube Assembly EC155

Start Date: 7/12/2013 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/18/2013 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

310

QC21- Final Inspection - Work Order Release

0.00

**\*310\***

QC

Memo

0.00

Quality Control

13/9/12  
H/B 59-4

# Picklist Print

Friday, July 12, 2013 12:41:26 PM

Work Order ID: 104674

**\*104674\***

Parent Item: D3507-1-BENT

**\*D3507-1-BENT\***

Parent Item Name: Skidtube Assembly EC135

Start Date: 7/12/2013

Required Date: 7/18/2013

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 10.09.17 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2962-150

Manufactured

No

100

Each

111.0000

1

2

**\*D2962-150\***

3,540 Outer Tube, Extrud

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*DP 13-9-5*

Location

Loc Qty

Loc Code

HALL

111

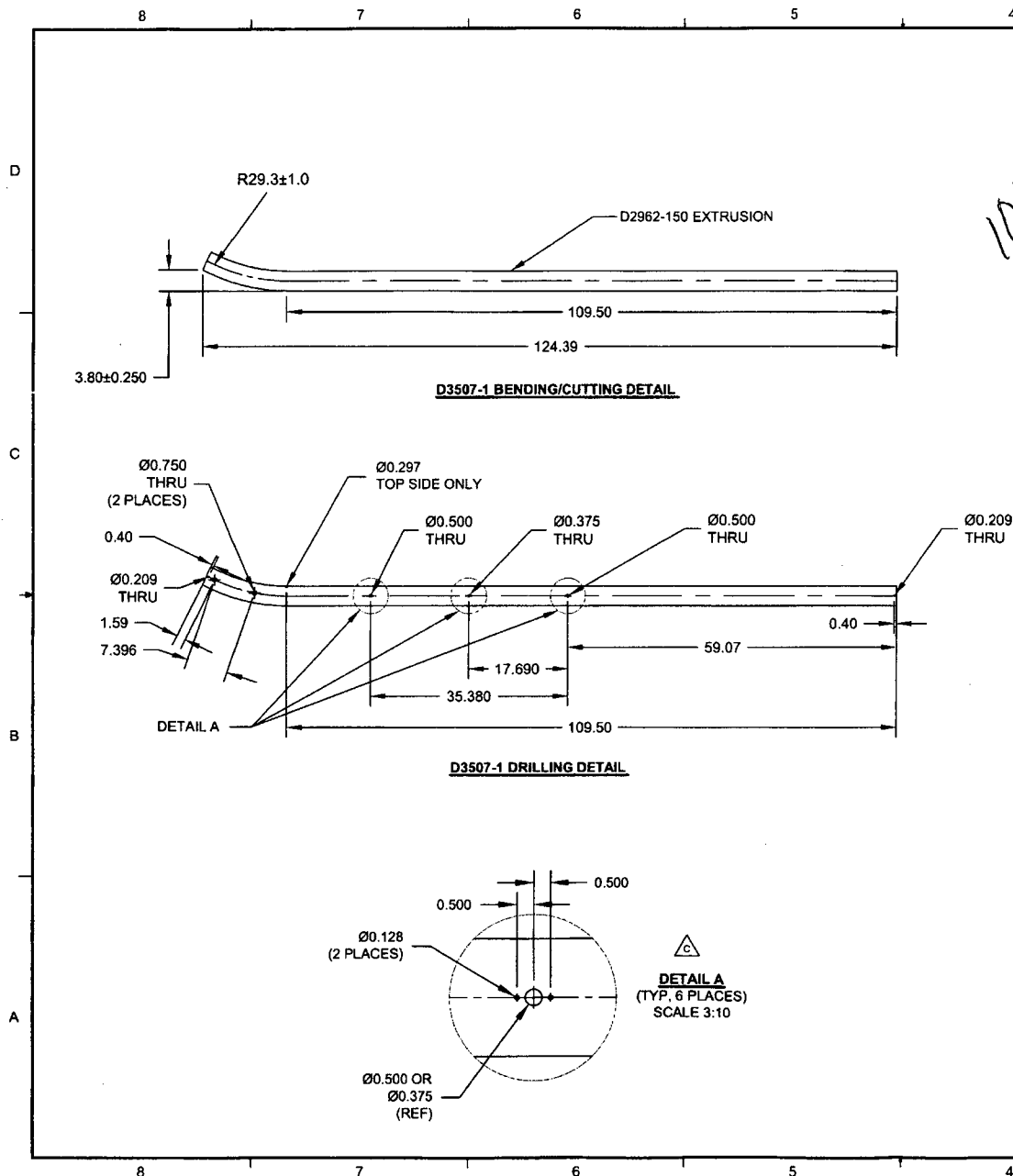
59934

16

90871

95

*2*



104674  
MB-07-19

Qty	Part Number	Description
X	D3507-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2965	CAP
1	D2965-3	CAP
4	D3492-041	PLUG ASSEMBLY
4	D3492-043	PLUG ASSEMBLY
2	D3492-047	PLUG ASSEMBLY
2	D3504-1	CROSS BOLT SPACER
1	D3504-3	CROSS BOLT SPACER
2	D3504-5	CROSS BOLT SPACER
1	D3505-1	WEB
4	D3506-1	DOUBLER
2	D3506-3	DOUBLER
1	D3508-1	WEARPLATE
1	D3508-3	WEARPLATE
1	D3508-5	WEARPLATE
1	D3508-7	WEARPLATE
1	D3558-1	GASKET
1	D3558-3	GASKET
1	D3558-5	GASKET
1	D3558-7	GASKET
38	AELS-1032-130	INSERT
1	AELS-1032-225	INSERT
31	AN3C4A	BOLT
2	AN3C5A	BOLT
2	AN526C1032-10	SCREW
33	AN960C10L	WASHER
12	MS20601AD4W3	RIVET

#### GENERAL NOTES:

- 1) FINISH:  
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3505-1 WEB. POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3. ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) DIMENSIONS: INCHES UNLESS OTHERWISE NOTED
- 4) WELDING TO BE DONE PER DART Q31 004
- 5) INSERT D3505-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING
- 6) USE DART DRILL TEMPLATE DT8868 TO LOCATE AND DRILL Ø0.297 HOLES (38 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION C-C (38 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- 7) DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS

C	ADD D3504-5, FOR SKID GEAR DEFLECTOR; CHANGE FWD CAP BOLT TO AN526C1032-10 SCREW	DC	07.09.19
B	ADD GASKET, CHANGE HARDWARE MATL	PH	06.11.01
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	JTC		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.09.19		

<b>DART AEROSPACE USA, INC</b> PORT HADLOCK, WA	
DRAWING NO. D3507	REV. C SHEET 1 OF 2
TITLE EC 135 SKIDTUBE	SCALE NTS
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RELEASED  
07.11.19

